

## Work Order ID 56766



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March 8, 2010 3:09:15 PM

Item ID: D3713-042

Accept



Setup Start



Revision ID:

Item Name: Lid Assembly

Stop



Start Date: 3/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/09/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3713	Rev B

100 Large Fab 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab  
1- drill holes in both D3715-1 as per dwg D3715 2- deburr 3- assemble as per dwg D3713 and weld as per QSI004*SM 10/03/11**(1x)*

110 Large Fab 0.00



Large Fab

Memo

0.00

Large Fab  
1- cut mesh as per dwg D3743 2- weld mesh as per dwg D3713*SAD 10-03-11*

120 QC5- Inspect part completeness to step on W/O



Memo

0.00

*Situs 17*QC  
Quality Control*R*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56766**

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Item ID: D3713-042

Accept



Setup Start



Revision ID:

Item Name: Lid Assembly

Stop



Start Date: 3/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/09/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

FL10-03-17

140



Powdercoat

Powder Coating

Black Sandtex(Ref 4.3 5.7) per QSI005 4.3

M105642

0.00

Memo

0.00

→ 9U 10/03/18

(X) ✓

START TIME: 9:15AM

FINISH TIME: 9:45AM

OVEN TEMPERATURE:

320°F

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BK 10-3-18

(D) ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID:	D3713-042	Accept		Setup	Start	
Revision ID:						
Item Name:	Lid Assembly				Stop	
Start Date:	3/08/10	Start Qty:	1.00			
Required Date:	3/09/10	Req'd Qty:	1.00			
Reference:				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish	HandFinishing	0.00							
Hand Finishing	Memo	0.00							
	1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4.2-apply armor shield over label on lid only								
	Label BT# 554390/115462 ARMOR BT# 105320								
170  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							

180  Packaging	Identify as per dwg & Stock Location: <u>CA</u>	0.00	SB	0/03/19	(1)	
Packaging	Memo	0.00				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 56766**

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Item ID: D3713-042

Accept



Setup Start



Revision ID:

Item Name: Lid Assembly

Stop



Start Date: 3/08/10 Start Qty: 1.00



Required Date: 3/09/10 Req'd Qty: 1.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

190

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

0.00

0.00

QC

Quality Control

J10.03.19

CL1013119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 8, 2010 3:09:13 PM

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Work Order ID: 56766



Parent Item: D3713-042



Parent Item Name: Lid Assembly

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Date: 3/08/10

Required Date: 3/09/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1 		Manufactured	No			100	Each	31.0000	2.0000			

Spacer Bushing

✓

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	31	
52832	11	
54658	20	

100	Each	45.0000	2.0000	
-----	------	---------	--------	--

D2581



Mounting Bracket

2x

SL 10/03/08

✓

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	5	
46086	2	
48428	1	
51120	2	

Main Warehouse

WA	40	
50872	1	
51745	2	
55918	37	

2x

SL 10/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 56766



Parent Item: D3713-042



Parent Item Name: Lid Assembly

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Date: 3/08/10

Required Date: 3/09/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3749-1 						100	Each	9.0000	3.0000			

Hinge Half

## Warehouse

### Location

Main Warehouse

M304EX0.75-16F

Purchased

No

	Loc Qty	Loc Code
ST	9	
38826	9	

Expanded Metal Flat SS

## Warehouse

### Location

Main Warehouse

MAT	838.0395065
111956	0.000017
112147	9.4736E-06
112949	19.84438
113205	0.0093
113497	0.1449
113555	667.7873
113904	150.2536

3x

SM 10/03/08

SAD

10-03-10

17.8947

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 56766

Parent Item: D3713-042

Parent Item Name: Lid Assembly



Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Date: 3/08/10

Required Date: 3/09/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065						100	f	129.7343	32.6547			

304 SQ Tube .75x.75x.065W

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

MAT	129.7342712	
113082	0.00419	
113245	15.9003842	
113683	0.30855	
113836	0.000047	
113956	113.5211	

Main Warehouse

WA	0.0000047	
----	-----------	--

D2329



Manufactured No

112398	0.0000047	
--------	-----------	--

110	Each	11.0000	1.0000	
-----	------	---------	--------	--

32.6547

SY 10/03/08

Label Plate

✓

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	11	
35686	2	
40488	9	

1x

SY 10/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

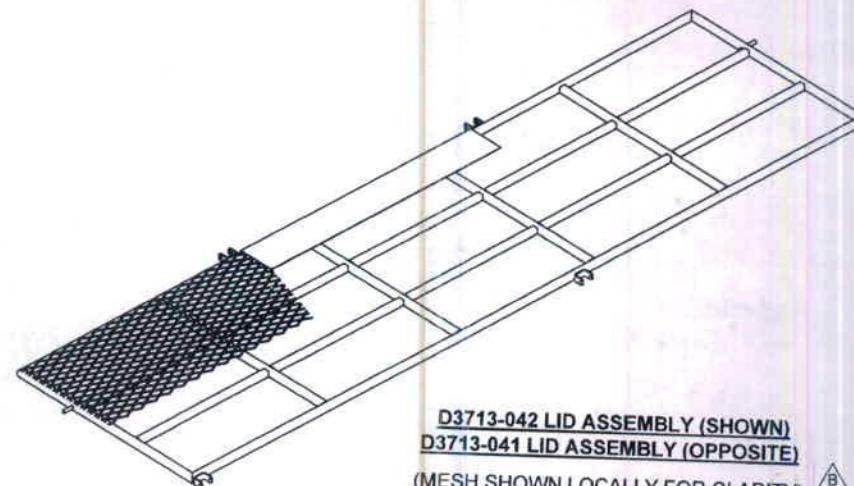
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8      7      6      5      4      3      2      1

D

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	RIB
3	3	D3749-1	MESH
			HINGE HALF



D3713-042 LID ASSEMBLY (SHOWN)  
D3713-041 LID ASSEMBLY (OPPOSITE)  
(MESH SHOWN LOCALLY FOR CLARITY)

W1056206  
08.03.11 AD

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B

B		SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY. NOTE 9 ADDED. ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 26.50 DIM 31.50 ZONE B5 LID ASSEMBLY WAS D3713-041. ZONE D6 31.50 DIM WAS 31.64. ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77. ZONE D3 & D2 FLAG NOTE 9 ADDED.	AJS	08.02.27
A		NEW ISSUE	AJS	08.02.01
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3713	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		LID ASSEMBLY	NTS	
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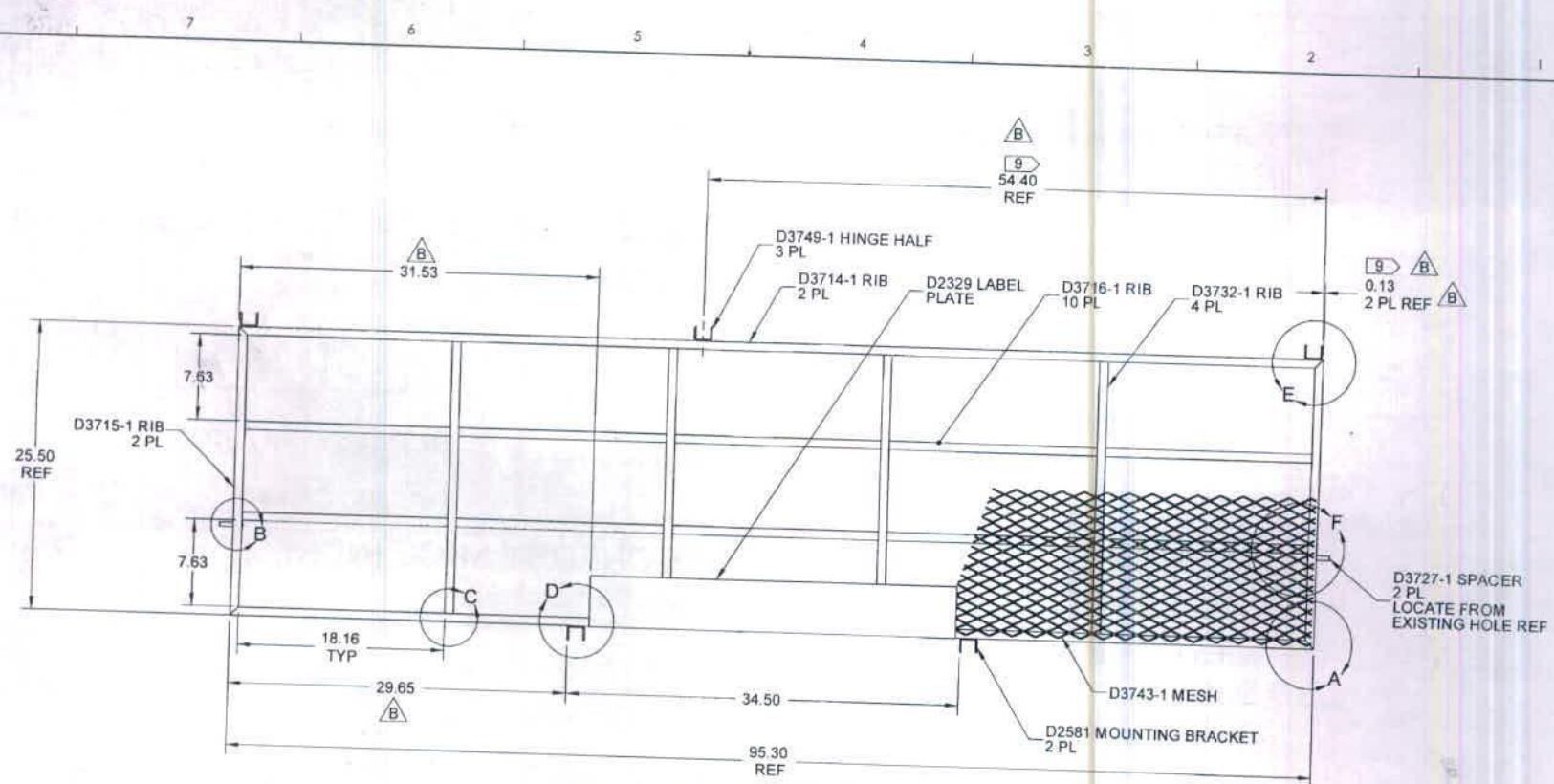
8      7      6      5      4      3      2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3713-042 LID ASSEMBLY (SHOWN)**

**D3713-041 LID ASSEMBLY (OPPOSITE)**

(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 2 OF 3
DE APPR.	<i>[Signature]</i>	TITLE
DATE	08.02.27	SCALE
		NTS

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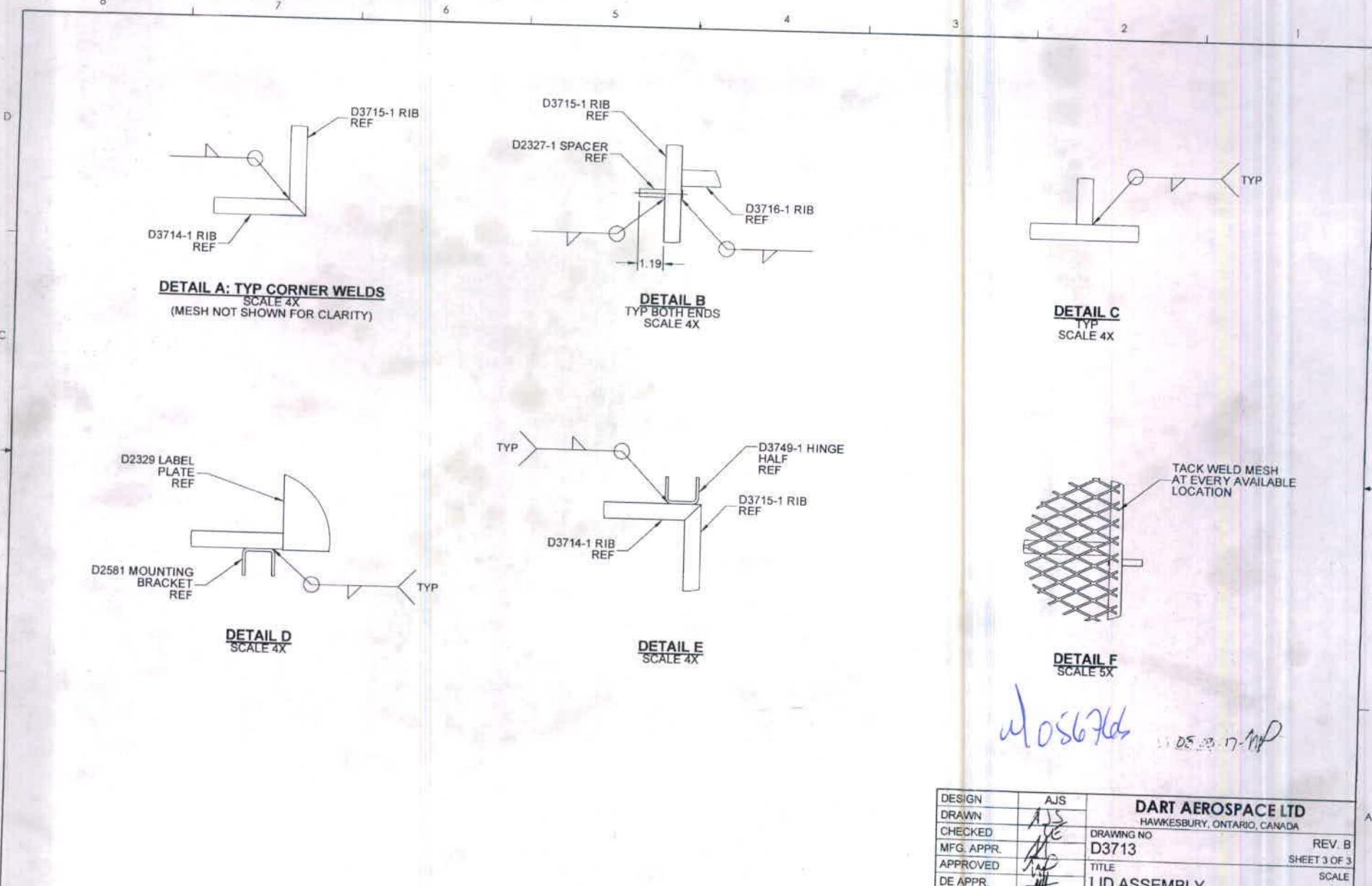
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	DRAWING NO
CHECKED	ME	D3713
MFG. APPR.	ME	REV. B
APPROVED	JAD	SHEET 3 OF 3
DE APPR.	ME	TITLE
DATE	08.02.27	SCALE
		NTS

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MoS676  
08.02.17-11P

